

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003689**Date Inspected:** 22-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Yu Dong Ping  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**Assembly Bay # 2**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. This QA inspector performed UT on deck panel DP042-001, weld 6 scanned 12 locations with 0 indications, weld 7 scanned 12 locations with 0 indications and weld 8 scanned 12 locations with 0 indications. QA inspector performed UT on deck panel DP063-001, weld 1 scanned 15 locations with 0 indications, weld 2 scanned 15 locations with 0 indications, weld 3 scanned 15 locations with 0 indications, weld 4 scanned 15 locations with 3 indications, weld 5 scanned 6 locations with 0 indications, weld 6 scanned 6 locations with 0 indications and weld 7 scanned 6 locations with 0 indications. A total of 114 tack welds were tested with 3 indications found. This QA inspector was informed by the task leader that a TL-6027 was not required at this time.

**Sub Assembly Bay # 4**

This QA observed ZPMC welder ID #068918, ID #053753, ID #067656 and ID #048659 performing Shielded

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## WELDING INSPECTION REPORT

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Metal Arc Welding (SMAW) in the (3G) position on 33 meter tower double diaphragm web plate to web plate Partial Joint Penetration welds, NSD1-SA322 A/B 13, 14, 15 and 16. The QA Inspector randomly observed ZPMC CWI Yu Dong Ping monitoring weld parameters. The welding parameters observed appeared to be in general conformance with the approved posted Welding Procedure Specification.

### Summary of Conversations:

No relevant conversations occurred this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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